

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008577**Date Inspected:** 28-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

North tower lift#1:- Caltrans QA Inspector observed five welders performed FCAW process on CJP weld for corner diagonal stiffener that connected skin plate B and C. The welding located at elevation 9m, 13m, 15m, 18m and 38m. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

South Tower Lift#3:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on interior diaphragms of skin plate B. The interior diaphragms located at the elevation 85.75m to 116.67m. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift#3:- Caltrans QA Inspector observed eight ZPMC welders in process FCAW process on interior diaphragms of skin plate C. The interior diaphragms located at the elevation 85.75m to 116.67m. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #11 South and North Tower Shop

West Tower Lift #2: - Caltrans QA inspector performed final VT and dry MT inspection on welds of diagonal plates for west tower lift #2. WSD1-TL6H/L-130, WSD1-TL6C/L-145, 37, WSD1-TL6G/L-114, WSD1-TL6G/L-35, WSD1-TL6F/L-134, WSD1-TL6C/L-169, 62, WSD1-TL6J/L-29, 31, WSD1-TL6H/L-53, 55,

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150, 152, WSD1-TL6G/L-92, 94, WSD1-TL6E/L-36, 38, 61, 63, WSD1-TL6D/L-36, 38, 98, 100, WSD1-TL6J/L-19, 21, WSD1-TL6G/L-77, 79, WSD1-TL6F/L-117, 119, WSD1-TL6E/L-21, 23, 148, 150, WSD1-TL6D/L-21, 23, 81, 83. The welds for VT and MT inspection have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans inspection, the four CJP stiffener welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

West Tower lift#1:- Caltrans QA Inspector observed six ZPMC grinders in process of grinding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 18m to 47.6m diaphragm sections that connected skin plate E of west tower lift #1. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinoved 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
